



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB877212-08-7
Job Sheet 192392



Part No: RB877212-08-7

Job Qty: 6 pcs

Part Name: Cutter, Ø1-1/2 x 5/8



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB877212-08 Rev D IPP Rev. A 19.02.21 New issue DP Verify DD/IPP Rev. B 19.03.20 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	6 pcs	5/3/19	5/3/19	0.00	1.50	SL-154 - 1		
120	QC 2	6 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S175989



Part: RB877212-08-7

Job No: 192392

Serial No/Batch: S175989

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/15/19

				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
130 QC 8	6 pcs	5/3/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Outsource - 1 - Heat Treat	6 pcs	5/3/19		ATL002-VC	10
141 Packaging 2-1 - Receive - B4B	6 pcs	5/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
142 QC 6	6 pcs	5/3/19	0.00 0.00	QC 6 - 40	
160 Outsource - 16 - Grinding	6 pcs	5/3/19		AFF001-VC	
161 Packaging 2-2 - Receive - B4B	6 pcs	5/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
162 QC 6	6 pcs	5/3/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
180 Outsource - 12 - Black Oxide	6 pcs	5/3/19		ATL002-VC	
190 Packaging 2-3 - Receive - B4B	6 pcs	5/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
200 QC 6	6 pcs	5/3/19	0.00 0.00	QC 6 - 40	
210 Packaging 3-1 - Stock - B4B	6 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	

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all sketched*

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2019-05-03
MAY 15 2019
MAY 22 2019
JUN 07 2019
MAY 17 2019
JUN 17 2019

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9-89

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	6 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS JUN 17 2019
21
9.55

AA
140B

Part Op 110 - MORI SL-154 LATHE - 1-Machine as per DWG. FC731 FOLIO REV: _____ DWG REV: _____ 2-
Descriptions: Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Outsource process - Heat Treat 1--Issue P/O; _____ RC 50-60 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO GRINDER Atlantic Heat Treat to ship directly to KG grinding.

160 - Outside Processing - Grinding - 1--Issue P/O to KG Grinding; P/O _____ 2-Grind as per DWG. 3-

Certificate of Conformity is required ***NOTE drop ship to surface finish***KG grinding to ship directly to HEAT TREAT***

162 - QC6- All purchased or subcontracted products

180 - -Issue P/O; 43692 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-

16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;

O1 -Certificate of Conformity is required

190 - Receive & Inspect for Damage & Mat'l Certs

210 - Identify as per dwg & Stock Location: _____

220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R1.500	Tool Steel Round Bar 1.500 dia.	.3960 ft (.066 ea)	110-SL-154 - 1	<u>575989</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-O1-R1.500	0	4	0

Allocated Container Detail

Qty	Container No	Location	Init
0	S175990	mat009-l	_____

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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RB877212-08-7
Job Sheet 192392



Part No: RB877212-08-7

Job Qty: 2 pcs *6 inf*

Part Name: Cutter, Ø1-1/2 x 5/8



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 5/3/19 *May 9*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB877212-08 Rev D IPP Rev. A 19.02.21 New issue DP Verify DD/IPP Rev. B 19.03.20 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	2 pcs	5/3/19	5/3/19	0.00	0.50	SL-154 - 1		<i>19/04/29</i>
120	QC 2	2 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		<i>19/04/29</i>
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S175989



Part: RB877212 - 08 - 7

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1270 Aberdeen Street
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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/29/19

Plex 3/22/19 9:50 AM Dart.lajeunesse.marie

130	QC 8	2 pcs	5/3/19	0.00 0.00	QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
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140	Outsource - 1 - Heat Treat	2 pcs	5/3/19		ATL002-VC	10
142	Outsource - 16 - Grinding	2 pcs	5/3/19		AFF001-VC	
145	Outsource - 12 - Black Oxide	2 pcs	5/3/19		ATL002-VC	
150	Packaging 2-1 - Receive - B4B	2 pcs	5/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	

Plex 3/22/19 9:50 AM Dart.lajeunesse.marie

					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160 QC 6	2 pcs	5/3/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
210 Packaging 3-1 - Stock - B4B	2 pcs	5/3/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
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					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
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					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	2 pcs	5/3/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - MORI SL-154 LATHE - 1-Machine as per DWG. FC 731 FOLIO REV: AA DWG REV:
 Descriptions: 2 2-Debur

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Outsource process - Heat Treat 1--Issue P/O; _____ RC 50-60 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO GRINDER Atlantic Heat Treat to ship directly to KG grinding.

142 - Outside Processing - Grinding - 1--Issue P/O to KG Grinding; P/O _____ 2-Grind as per DWG. 3- Certificate of Conformity is required ***NOTE drop ship to surface finish***KG grinding to ship directly to ATLANTIC HEAT TREAT***

145 - -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required

150 - Receive & Inspect for Damage & Mat'l Certs
160 - QC6- All purchased or subcontracted products
210 - Identify as per dwg & Stock Location: _____
220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R1.500	Tool Steel Round Bar 1.500 dia.	.1320 ft (.066 ea)	110-SL-154 - 1	5046138

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-O1-R1.500	0	5	0

Part Specifications

Specifications could not be found.

Plex 3/22/19 9:50 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

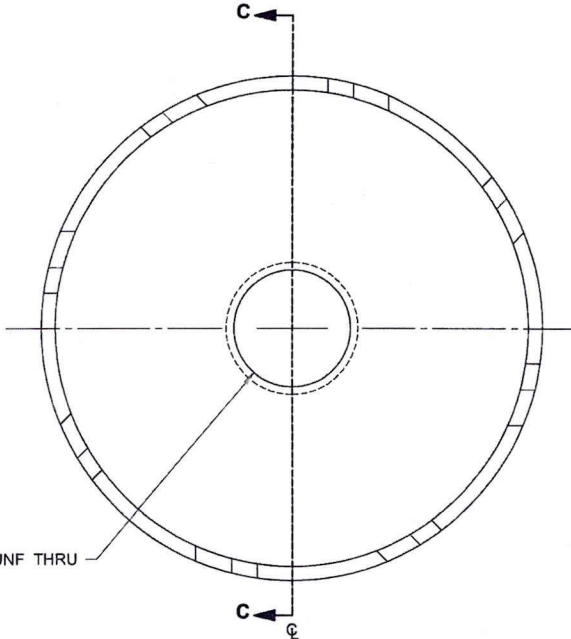
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

8 7 6 5 4 3 2 1

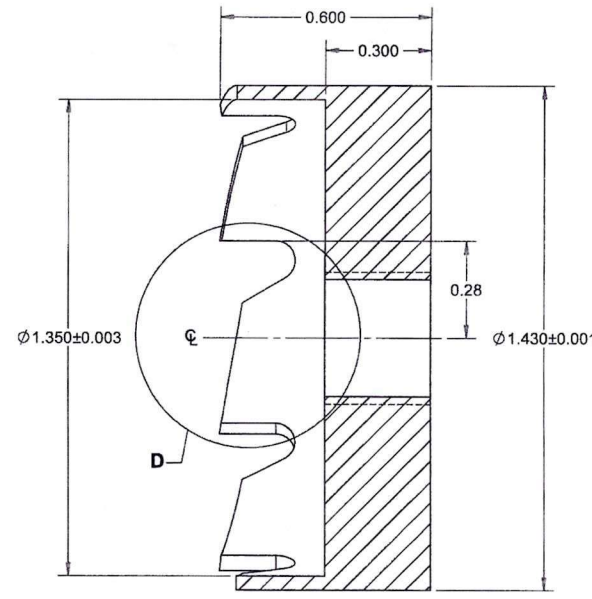
D
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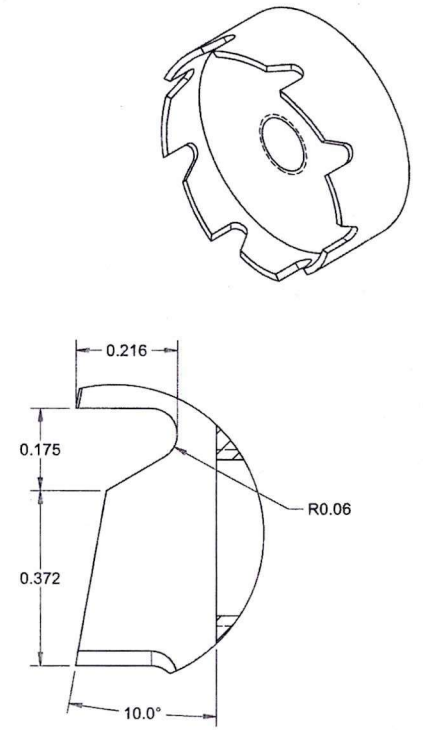


3/8-24 UNF THRU

RB877212-08-7 CUTTER



SECTION C-C



DETAIL D
8 PL EQUALLY SPACED

- NOTES:
- 1) MATERIAL: O1
 - 2) HEAT TREAT: 50-60 RC
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
 X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
 X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192392 MJS
14-0322

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 5 OF 11
APPROVED	WJ	TITLE	SCALE
		TAIL ROTOR BEARING CUTTER	NTS
DATE	3/21/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043375



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043375

PO Date: 5/3/19

Due Date: 5/9/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192149	C45-15	Keeperless Adapter 1-Issue P/O to ATLANTIC HEAT TREAT; P/O RC _44- 46 2-Bead blast 3-Material type; 4140 4- Certificate of Conformity is required	Firmed	-	5/9/19	6 pcs	0 pcs	6 pcs	\$28.3333/pcs	\$170.00
2	192392	RB877212-08-7	Cutter, Ø1-1/2 x 5/8 Outsource process - Heat Treat 1-Issue P/O; RC 50-60 2-Bead blast 3- Certificate of Conformity is required MT-O1-R1.500 Tool Steel Round Bar 1.5 dia	Firmed	-	5/9/19	6 pcs	0 pcs	6 pcs	\$12.50/pcs	\$75.00
3	190623	20NR-84	Spacer for Dual Cage 6 1-Issue P/O; RC 33-37 2-Bead blast 3-Material type; 1045 4- Certificate of Conformity is required	Firmed	-	5/9/19	4 pcs	0 pcs	4 pcs	\$26.90/pcs	\$107.60
	191157			Firmed	-	5/9/19	6 pcs	0 pcs	6 pcs	\$26.90/pcs	\$161.40
Sub Total:							10	0	10		\$269.00

DAS
40
9-89

6 X MAY 15 2019



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043375



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	R194439	20NR-84A	Spacer for Dual Cage 4 1- Issue P/O _____ RC 33-37 2-Bead blast 3- Certificate of Conformity is required MAT'L 1045	Firmed	-	5/9/19	2 pcs	0 pcs	2 pcs	\$67.25/pcs	\$134.50
6	R194446	20NR-84B	Spacer Dual Cage 4, 5/8" hole 1- Issue P/O _____ RC 33-37 2-Bead blast 3- Certificate of Conformity is required MAT'L 1045	Firmed	-	5/9/19	3 pcs	0 pcs	3 pcs	\$44.8333/pcs	\$134.50
Grand Total:											\$783.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/14/19 1:01 PM Dart.Guerin.Kimberley

Shipping Ticket

Sold To: 1448**DART AEROSPACE LTD.**
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 162923**DART AEROSPACE LTD.**
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB043375 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
✓ 6 PCS	MATERIAL 01 SANDBLAST AND HEAT TREAT TO 50-60RC C OF C, PRT# RB877212-08-7, JOB# 192392 ✓	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

6

Pounds Shipped:

1.00

RECEIVED

MAY 14 2019

DART AEROSPACE LTD.*Sgr**5-13-19*

Order No.: 165981

Shipped Complete

Quantity Shipped:

6.00

Received By:

Date:

Pounds Shipped:

1.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 05/07/2019

Certification

Date: 05/13/2019

Entry Date: 05/07/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB043375

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
6	6 PCS MATERIAL 01 SANDBLAST AND HEAT TREAT TO 50-60RC C OF C, PRT# RB877212-08-7, JOB# 192392	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:Harden ROCKWE 50. 60. 59. TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 59 RC AS PER CUSTOMER REQUESTDAS
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STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEANE SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043517



Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043517
PO Date: 5/22/19
Due Date: 5/31/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground
Pymt Terms: Net 30

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192392	RB877212-08-7	Cutter, Ø1-1/2 x 5/8 Outside Processing - Grinding - 1--Issue P/O to KG Grinding; P/O _____ 2-Grind as per DWG. 3- Certificate of Conformity is required ***NOTE drop ship to surface finish***KG grinding to ship directly to HEAT TREAT***	Firmed	-	5/31/19	6 pcs	0 pcs	6 pcs	\$60.00/pcs	\$360.00
Grand Total:											\$360.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043517



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/28/19 7:12 AM dart.lavoie.chantal

AFFUTAGE K.G. INC. K.G. GRINDING INC.

11455 avenue Philippe Panneton
Montréal, Québec H1E 4M1
Tel: (514) 323-0192
Fax: (514) 323-6631

Packing Slip

Packing Slip No.: 10749
Date: 05-06-2019
Page: 1

Sold to:	Ship to:
DART AEROSPACE LTD CHANTAL LAVOIE 1270 Aberdeen Street Hawkesbury, On K6A 1K7	DART AEROSPACE LTD CHANTAL LAVOIE 1270 Aberdeen Street Hawkesbury, On K6A 1K7
Order No.: HB043517	Sold By:
Shipped By:	Tracking No.:

Item No.	Unit	Description	Ordered	Quantity Shipped	B/O
D.Modification	Each	Cutter, Ø1-1/2 x 5/8	6	6	

AFFUTAGE K.G. INC. K.G. GRINDING INC.

CERTIFICAT DE CONFORMITÉ

11455 Philippe Panneton
Montreal, Quebec, H1E 4M1
E-mail: sales@kggrinding.com
Website: www.kggrinding.com

Tel: 514-323-0192
Fax: 514-323-6631

CLIENT: Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Contact: Chantal Lavoie

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QTY	EDP	DESCRIPTION	Results
6	RB877212-08-7	Cutter, Ø1-1/2 x 5/8 Outside Processing	PASS

Parts above were manufactured to the dimensions according to quotation number #7309 and

PO: ~~HB043554~~ HB043517 JUN 07 2019
CL



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043692



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043692

PO Date: 6/11/19

Due Date: 6/18/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-13

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193353	RBE350A93-3303-02-1	Receiver Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Material A36/1018/1020 -Certificate of Conformity is required	Firmed	-	6/18/19	8 pcs	0 pcs	8 pcs	\$5.41/pcs	\$43.28
2	192392	RB877212-08-7	Cutter, Ø1-1/2 x 5/8 -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required	Firmed	-	6/18/19	6 pcs	0 pcs	6 pcs	\$2.60/pcs	\$15.60
3	194533	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/18/19	8 pcs	0 pcs	8 pcs	\$2.40/pcs	\$19.20

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043692



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193354	RBE350A93-3303-02-3	Extractor Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Material A36/1018/1020 -Certificate of Conformity is required	Firmed	-	6/18/19	11 pcs	0 pcs	11 pcs	\$2.65/pcs	\$29.15
5	194900	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/18/19	8 pcs	0 pcs	8 pcs	\$1.50/pcs	\$12.00
6	194532	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/18/19	8 pcs	0 pcs	8 pcs	\$1.50/pcs	\$12.00
Grand Total:										\$131.23	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/13/19 2:41 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(019931-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

019931- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
13-Jun-2019		SVETLANA DORZHIYEVA		POHB043692				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3303-02-1 ✓ Rev.	RBE350A93-3303-02-1 01 -BLACK OXIDE FINISH M MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	8	8 ✓	0	0	0
2	RB877212-08-7 ✓ Rev.	RB877212-08-7 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	6	6 ✓	0	0	0
3	RBE350A94-2706-00-05 ✓ Rev.	RBE350A94-2706-00-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8 ✓	0	0	0
4	RBE350A93-3303-02-3 ✓ Rev.	RBE350A93-3303-02-3 01 -BLACK OXIDE MIL-C-13942C, CLASS 1	BLACK-OXIDE CH	10	10 ✓	0	0	0
5	RBE350A94-2706-00-01 ✓ Rev.	RBE350A94-2706-00-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8 ✓	0	0	0
6	RBE350A94-2706-00-03 ✓ Rev.	RBE350A94-2706-00-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	8	8 ✓	0	0	0

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RECEIVED

JUN 14 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.